

A5AP

Work Order ID 70068

Thursday, May 26, 2011 10:20:20 AM



Page 1

Item ID: D3296-1

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 5/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:



Date: 1105-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3296	Rev A

100



FLOW WATER JET

Waterjet

Memo

0.00

1105-26

FLOW CNC Waterjet

2024.063

I-Cut as per Dwg D3296 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

(8) only enough
work for
(8)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

1105-26

Pto →

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

8 u/15/27

(X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3296-1 PAR #: N/A Fault Category: Small Tab NCR: Yes No DQA: A Date: 11-06-01

Resolution: Disposition: QA: N/C Closed: Date:

NCR: 70068

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/01	100	Pt Qty +4 parts screen Due to notches being cut in to part. R-L. machine manufac.	A 2/4/02	-Scrap + Doty. Reake m 11/3/01 QH+2	AB 5 11/05/01	A G 11/05/01	B OSDC/12	S 11/05/01
		Set a mark when there is present in the L.C.						

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Small Fab

Small Fab

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Small Fab

Memo
Debug

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

8 BR 11-5-27.

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8x Øm 11/05/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC-Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70068

Thursday, May 26, 2011 10:20:20 AM



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Item ID: D3296-1

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 5/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

186

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11/13/20

JL80

170



QC

Quality Control

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/13/20
JL8011/05/20
JL

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 26, 2011 10:20:26 AM

Page 1

Work Order ID: 70068



Parent Item: D3296-1



Parent Item Name: Door Panel

Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C□05.10.14□Added step 14□KJ/EC□
IPP Rev:D Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased		No		100	sf	309.0700	0.6596	6.943158		 B11-5-26	

2024-T3 .063 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	309.07	
113867	0.19	
117018	40.38	
117392	268.5	117392

(10)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *70068*

PL 11-05-2L

D3161-7 HINGE

.063

D3296-1 DOOR
PANEL (1)

D3161-9
HINGE

0.125

D2419 HANDLE (1)
MS20470AD4-6 RIVET (1)
AN960JD6 WASHER (1)
D3296-3 DOOR PANEL (1)

0.240

13.563 (13 EQUAL SPACES)

Ø0.141 (TYP, 3 PLACES SHOWN)
MS20470AD4-4 RIVET
(25 PLACES)

Ø0.128
(TYP 11
PLACES)

RELEASED
04.07.11

DESIGN	DRAWN BY	DART AEROSPACE LTD
<i>IP</i>	<i>IP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>IP</i>	<i>IP</i>	D3296
DATE		TITLE
04.06.28		DOOR ASSEMBLY
A	04.06.28	NEW ISSUE



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

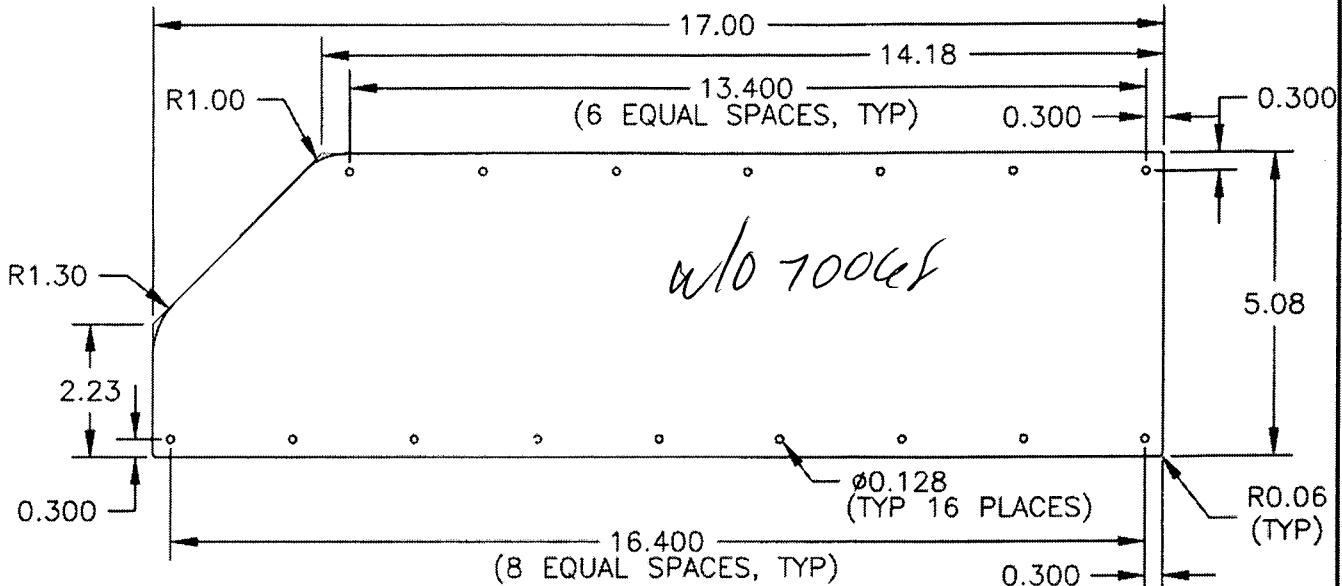
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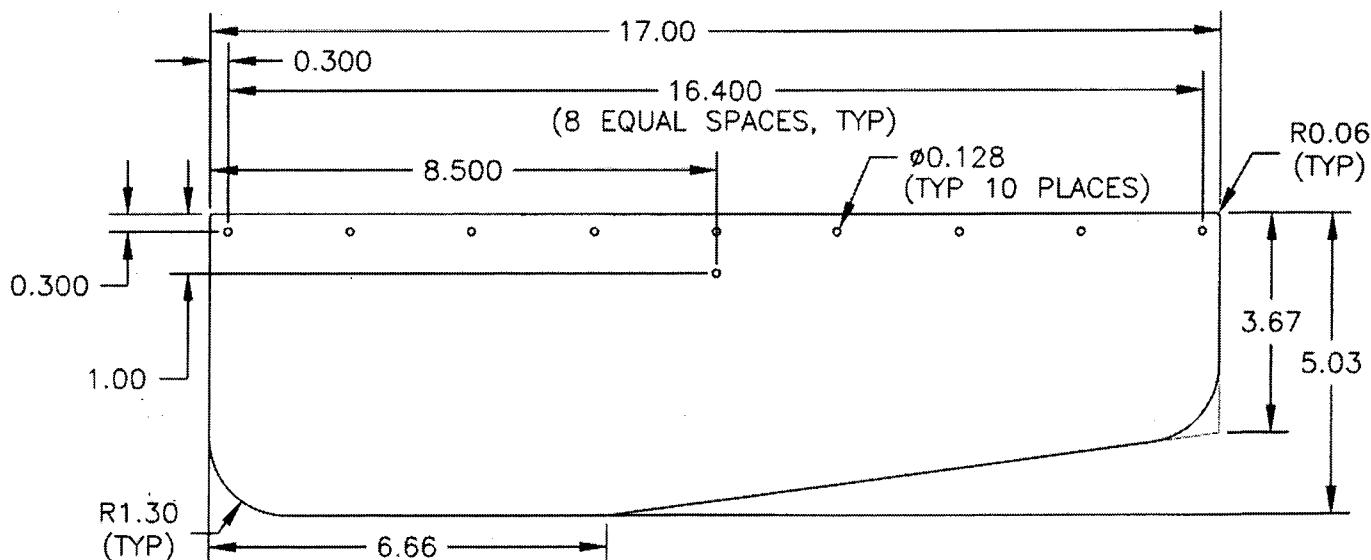


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DART

DESIGN CP	DRAWN BY IP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3296 REV. A 2 OF 2
DATE 04.06.28	TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	700668
Description: Door Panel	Part Number:	D3296-1
Inspection Dwg: D3296	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	1B	Audited by:	S	Prototype Approval:	N/A
Date:	11-5-3C	Date:	11/05/77	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	P/O D3296-041	KJ/JLM ✓ ✓

